

Date: Thursday, 3/2/2006 3:08:31 PM
User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: BRACKET ASSEMBLY
Job Number	: 26043		
Estimate Number	: 10290		
P.O. Number	: N/A	Part Number	: D3121144
This Issue	: 3/2/2006	S.O. No.	: N/A
Prsht Rev.	: NC	Drawing Number	: D3121 REV C2
First Issue	: N/A	Project Number	: N/A
Previous Run	: 25557B	Drawing Revision	: C2
		Material	: N/A
Written By	: <u>SEE COMMENT BELOW</u>	Due Date	: 3/30/2006
Checked & Approved By	: <u>JL 06.03.02</u>	Qty:	2 Um: Each
Comment	: Est Rev: Pick: A 04.02.18 New issue KJ/DS		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M174B1000X02000	17-4 SS Bar
-----	-----------------	-------------



Comment: Qty.: 0.3864 f(s)/Unit Total: 0.7728 f(s)
Material: 17-4 SS Bar per AMS 5604/5643
(M17-4-B1.000x02.000)
Identify for D3121-114
Batch: M19712

J.L 06.03.14

2

2.0	BAND SAW	BAND SAW
-----	----------	----------



Comment: BAND SAW
Cut blanks: (1.000" x 2.000") 4.425" long

J.L 06.03.14

2

3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
-----	-------	--------------------------------



Comment: HAAS CNC VERTICAL MACHINING #1

1-Machine D3121-114 as per Folio FA330 and Dwg D3121 Identify as D3121-114

2-Deburr

3-Scribe batch number

J.L 06.03.15

2

4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
-----	-----	--



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

J.L 06.03.14

2

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D3121-144 PAR #: N/A Fault Category: Red/Machined Parts NCR: Yes No DQA: Date: 06/03/15
 QA: N/C Closed: Date: 06.03.16

NCR: <u>26043</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
06-06-14	3	All four slots are shifted down on one part. 0.160" dim is 0.142". See attached email	<u>UP</u> 06.03.15 per Q51042	Part is OK per email (attached)	<u>J.L</u> 06.03.15	<u>AB</u> 06.03.15	<u>UP</u> 06.03.15 per Q51042	<u>AB</u> 06.03.15

NOTE: Date & initial all entries

Date: Thursday, 3/2/2006 3:08:31 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BRACKET ASSEMBLY

Job Number: 26043

Part Number: D3121144

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

QC8

SECOND CHECK



Comment: SECOND CHECK

En 06/03/15 2

6.0

D312121

Bolt



Comment: Qty.: 2.0000 Each(s)/Unit Total: 4.0000 Each(s)

Pick:

Qty Part Number

Description Batch

2 D3121-21

Bolt

B25560

J.L 06.03.15 2

7.0

D3121241

Bearing Assembly



Comment: Qty.: 2.0000 Each(s)/Unit Total: 4.0000 Each(s)

Pick:

Qty Part Number

Description Batch

2 D3121-241 Bearing Ass

B25477

J.L 06.03.15 2

8.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Assemble D3121-143 as per Dwg D3121.

J.L 06.03.15 2

9.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

En 06/03/15 2

10.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

SI408

C 206/03/15 (2)

11.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

SP 06/03/16 (2)

Job Completion



h 06/03/15

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	
Description: Bracket		Part Number:	D3121-114
Inspection Dwg: D3121	Rev: C2	Page 1 of 2	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.080	+/-0.010	.081	✓			
0.300	+/-0.010	.300	✓			
R0.375	+/-0.010	.375	✓			
1.54	+/-0.030	1.541	✓			
0.350	+/-0.010	.351				
R0.250	+/-0.010	.250	✓			
1.800	+/-0.030	1.803	✓			
Ø0.392	+0.002/-0.000	.392	✓			
Ø0.201	+0.005/-0.000	.202	✓			
0.100	+/-0.010	.099	✓			
2.540	+/-0.010	2.538	✓			
1.590	+/-0.010	1.588	✓			
0.160	+/-0.010	.158	✓			
0.400	+/-0.010	.409	✓			
1.220	+/-0.010	1.229	✓			
1.600	+/-0.010	1.603	✓			
3.80	+/-0.030	3.810	✓			
1.800	+/-0.010	1.803	✓			
R0.500	+/-0.010	.500	✓			
0.130	+/-0.010	.134	✓			
3.41	+/-0.030	3.410	✓			
3.65	+/-0.030	3.648	✓			
2.24	+/-0.030	2.230	✓			
45°	+/-0.1°	45°	✓			
R0.250	+/-0.010	.250	✓			
3.97	+/-0.030	3.972	✓			
R0.38	+/-0.030	.38	✓			
Ø0.392	+0.002/-0.000	.392	✓			
Ø0.201	+0.005/-0.000	.202	✓			
0.100	+/-0.010	.100	✓			
0.268	+/-0.010	.267	✓			
R0.260	+/-0.010	.260	✓			
0.080	+/-0.010	.081	✓			
0.300	+/-0.010	.302	✓			

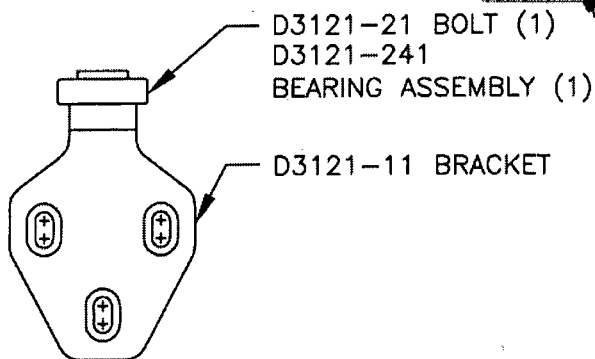
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10/05/06



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		D3121	SHEET 1 OF 10
DATE		TITLE	SCALE
04.02.17		BRACKET ASSEMBLY	1:2
A	02.04.15	NEW ISSUE	
B	03.01.16	ADD RIDGES; ADD MAT'L PROP; FIX P/N ADD -141/-143/-144/-145/-146	
C	04.02.17	ADD CLEARANCE; USE -241 BEARING	
C1	04.03.26	3.97 WAS 4.00; 6.11 WAS 6.14	
C2	04.04.26	0.230 WAS 0.238	

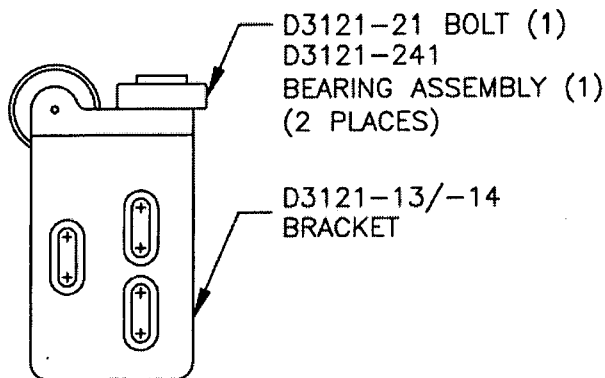
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04.03.01



D3121-21 BOLT (1)
D3121-241
BEARING ASSEMBLY (1)

D3121-11 BRACKET

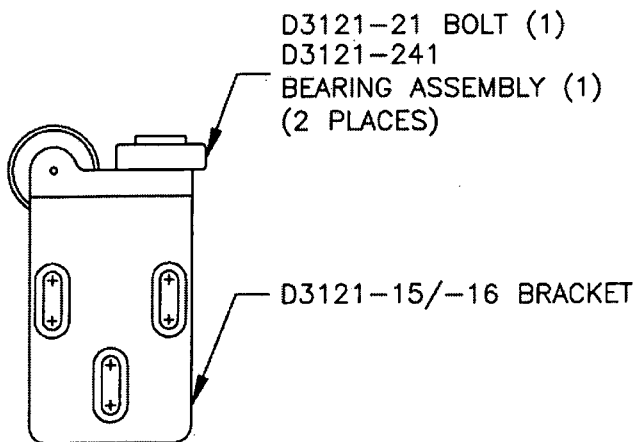
D3121-041 BRACKET ASSEMBLY
(REPLACES PREMIER P/N B30-23000-33)



D3121-21 BOLT (1)
D3121-241
BEARING ASSEMBLY (1)
(2 PLACES)

D3121-13/-14
BRACKET

**D3121-043 (SHOWN) / D3121-044 (OPPOSITE)
BRACKET ASSEMBLY**
(REPLACES PREMIER P/N B30-23000-37/-38)



D3121-21 BOLT (1)
D3121-241
BEARING ASSEMBLY (1)
(2 PLACES)

D3121-15/-16 BRACKET

**D3121-045 (SHOWN) / D3121-046 (OPPOSITE)
BRACKET ASSEMBLY**
(REPLACES PREMIER P/N B30-23000-35/-36)

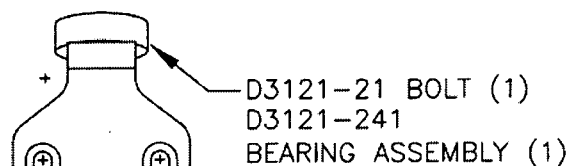
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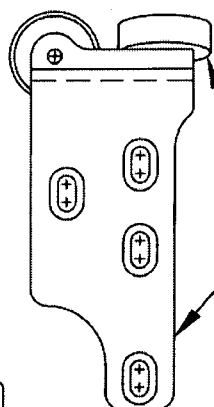
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CHECKED #	APPROVED #	DRAWING NO. D3121	REV. C SHEET 2 OF 10
DATE 04.02.17		TITLE BRACKET ASSEMBLY	SCALE 1:2



D3121-21 BOLT (1)
D3121-241
BEARING ASSEMBLY (1)

D3121-111 BRACKET

D3121-141 BRACKET ASSEMBLY
(REPLACES PREMIER P/N B30-23001-01)

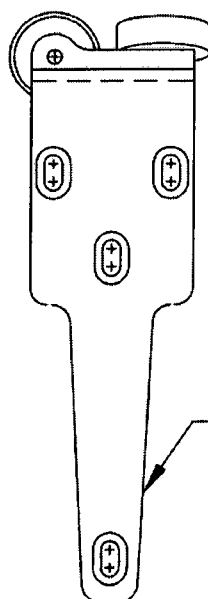


D3121-21 BOLT (1)
D3121-241 BEARING ASSEMBLY (1)
(2 PLACES)

D3121-113/-114 BRACKET

D3121-143 (SHOWN) / D3121-144 (OPPOSITE)
BRACKET ASSEMBLY
(REPLACES PREMIER P/N B30-23000-03/-04)

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D3121-21 BOLT (1)
D3121-241 BEARING ASSEMBLY (1)
(2 PLACES)

D3121-115/-116
BRACKET

D3121-145 (SHOWN) / D3121-146 (OPPOSITE)
BRACKET ASSEMBLY
(REPLACES PREMIER P/N B30-23000-05/-06)

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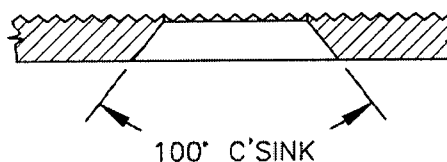
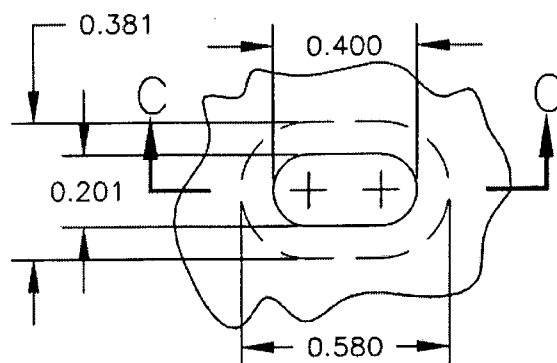
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DATE 04.02.17		TITLE BRACKET ASSEMBLY	SCALE 1:1

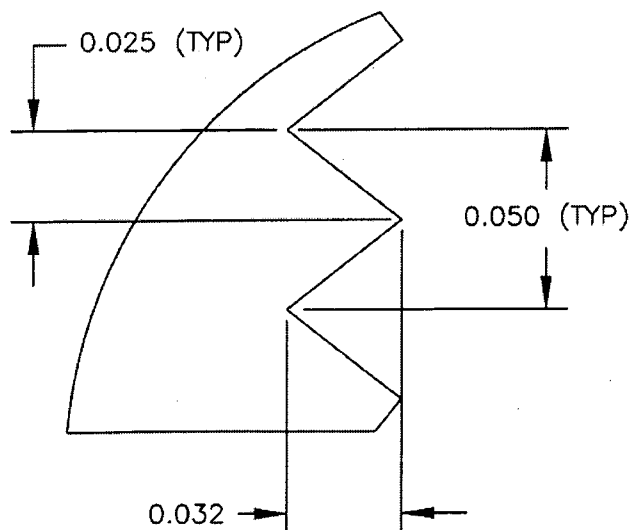
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DETAIL A:
SLOT DETAIL
SCALE 2:1
VIEW ROTATED



SECTION
C-C

DETAIL B:
RIDGE DETAIL
PARTIAL SECTION
SCALE 1:20



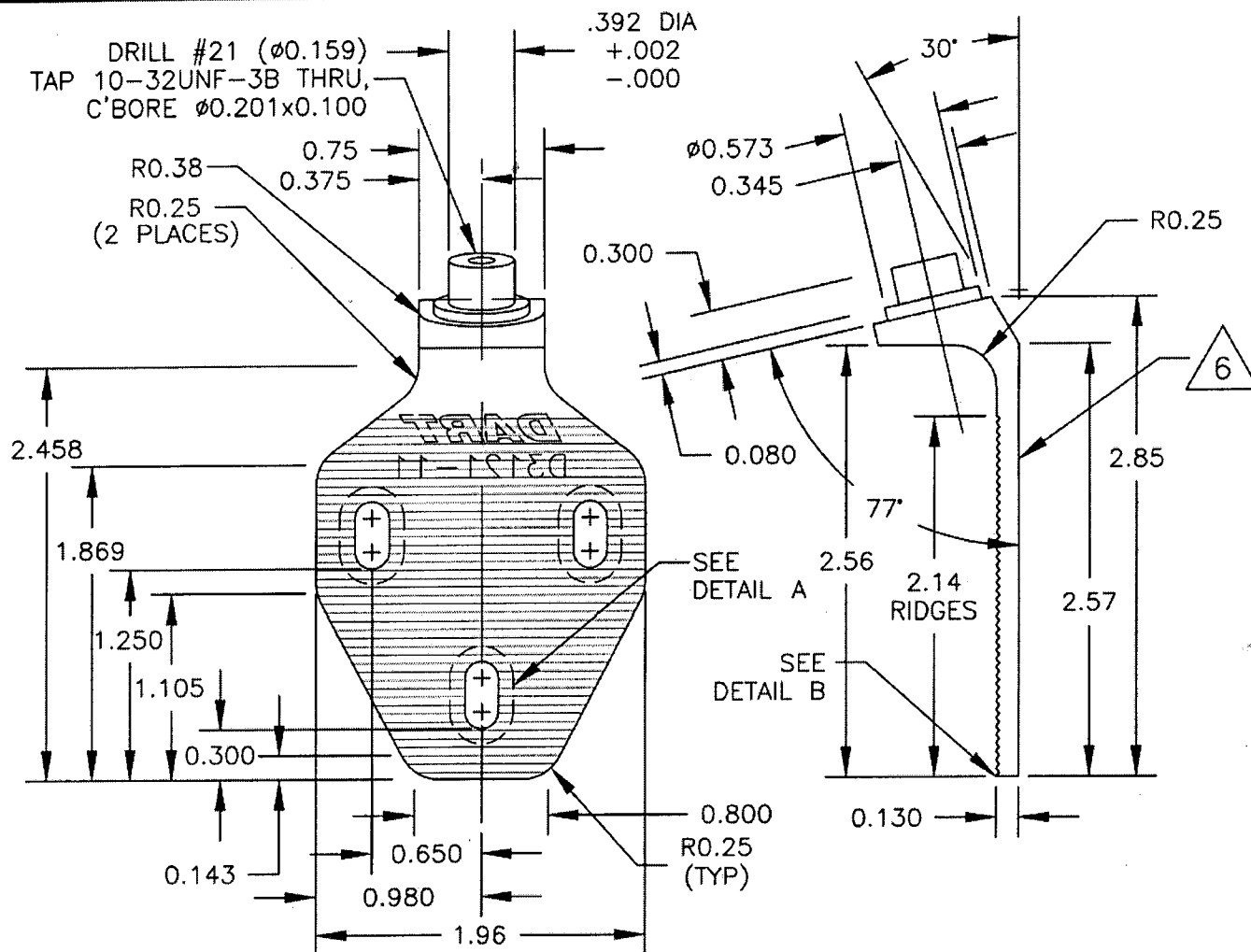
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DATE 04.02.17	TITLE BRACKET ASSEMBLY		SCALE 1:1



D3121-11 BRACKET

- 1) MATERIAL: 17-4 SS PER AMS 5604/5643 (REF DART SPEC. M17-4-B)
MIN ULTIMATE TENSILE = 150 ksi
MIN YIELD TENSILE = 100 ksi
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 5) ENGRAVE DART P/N & LOGO AS SHOWN
- 6) HOLE IN SPIGOT TO BE CONCENTRIC WITHIN 0.005





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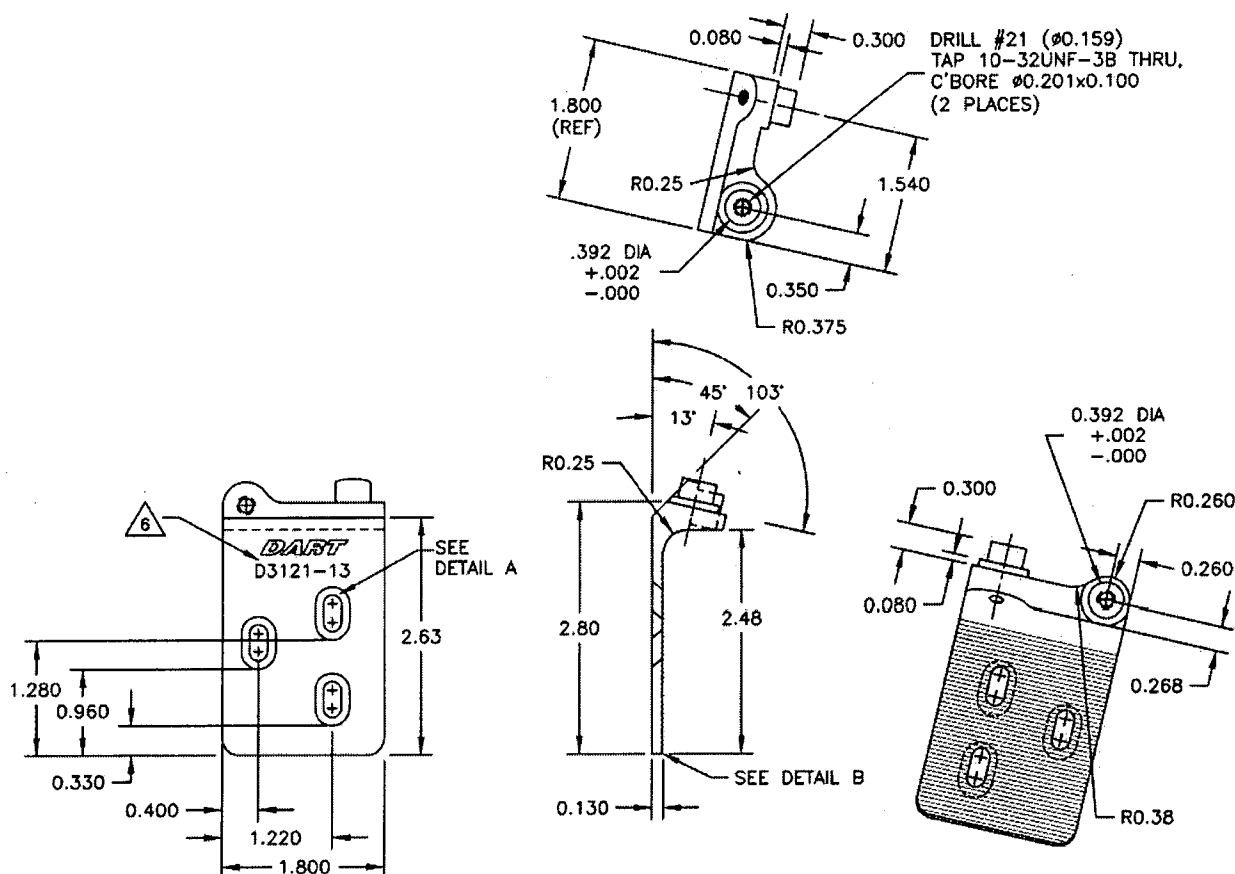
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DATE 04.02.18		TITLE BRACKET ASSEMBLY	SCALE 1:2



D3121-13 BRACKET (SHOWN)
D3121-14 BRACKET (OPPOSITE)

- 1) MATERIAL: 17-4 SS PER AMS 5604/5643 (REF DART SPEC. M17-4-B)
MIN ULTIMATE TENSILE STRENGTH = 150 ksi
MIN YIELD TENSILE STRENGTH = 100 ksi
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 5) ENGRAVE DART P/N & LOGO AS SHOWN
- 6) HOLE IN SPIGOT TO BE CONCENTRIC WITHIN 0.005

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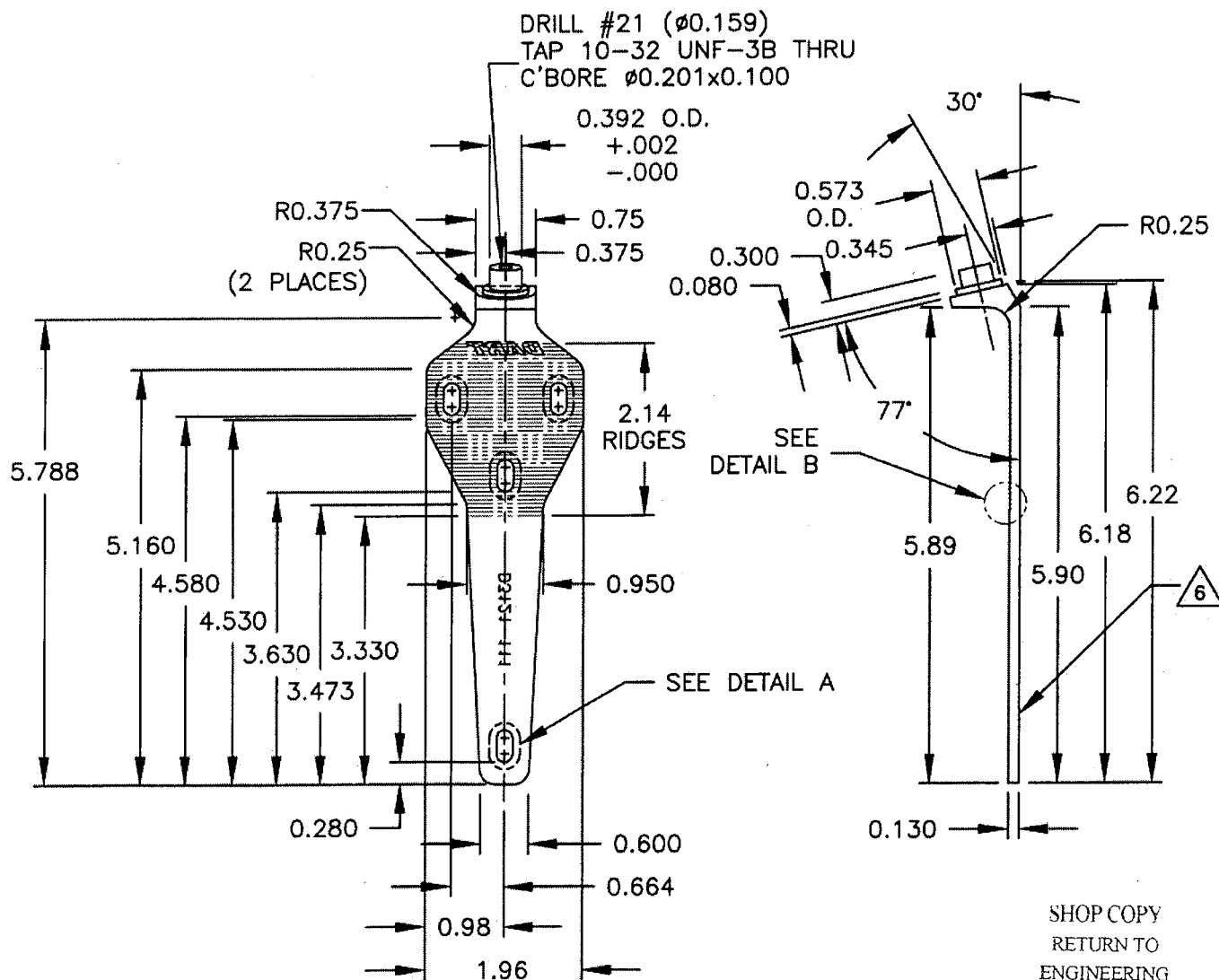
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CHECKED #	APPROVED #	DRAWING NO. D3121	REV. C SHEET 7 OF 10
DATE 04.02.18		TITLE BRACKET ASSEMBLY	SCALE 1:2



D3121-111 BRACKET

- 1) REPLACES PREMIER P/N B32-23001-11
- 2) MATERIAL: 17-4 SS PER AMS 5604/5643 (REF DART SPEC. M17-4-B)
MIN ULTIMATE TENSILE = 150 ksi
MIN YIELD TENSILE = 100 ksi
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 6) ENGRAVE DART P/N & LOGO IN AREAS SHOWN
- 7) HOLE IN SPIGOT TO BE CONCENTRIC WITHIN 0.005

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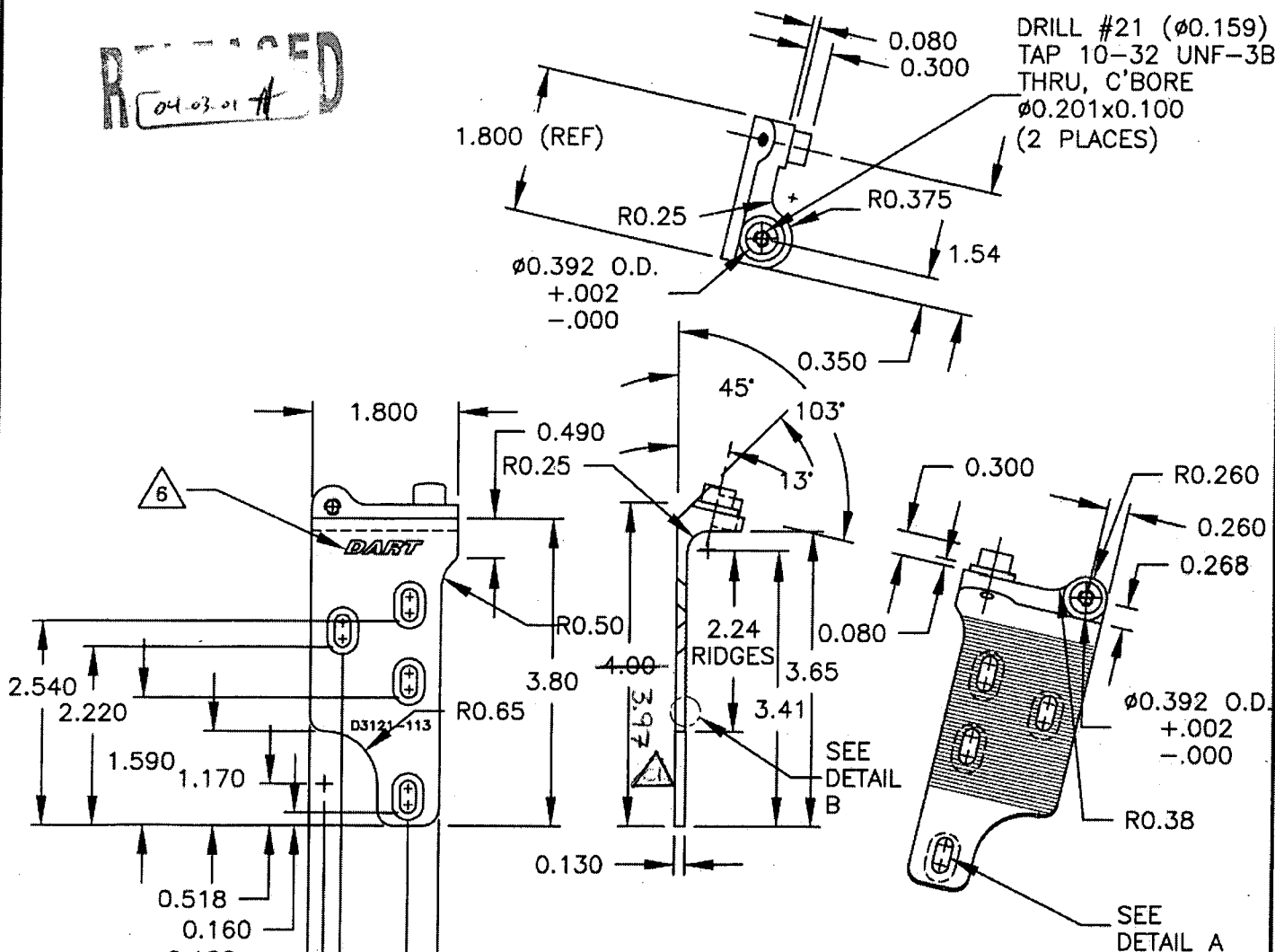
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CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3121	REV. C SHEET 8 OF 10
DATE 04.02.18	TITLE BRACKET ASSEMBLY		SCALE 1:2

RECEIVED
04.03.01 *[Signature]*



D3121-113 BRACKET (SHOWN)

D3121-114 BRACKET (OPPOSITE)

- 1) D3121-113 REPLACES PREMIER P/N B32-23001-13
D3121-114 REPLACES PREMIER P/N B32-23001-14
- 2) MATERIAL: 17-4 SS PER AMS 5604/5643
(REF DART SPEC. M17-4-B)
MIN ULTIMATE TENSILE STRENGTH = 150 ksi
MIN YIELD TENSILE STRENGTH = 100 ksi
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 6) ENGRAVE DART P/N & LOGO IN AREAS SHOWN
- 7) HOLE IN SPIGOT TO BE CONCENTRIC WITHIN 0.005

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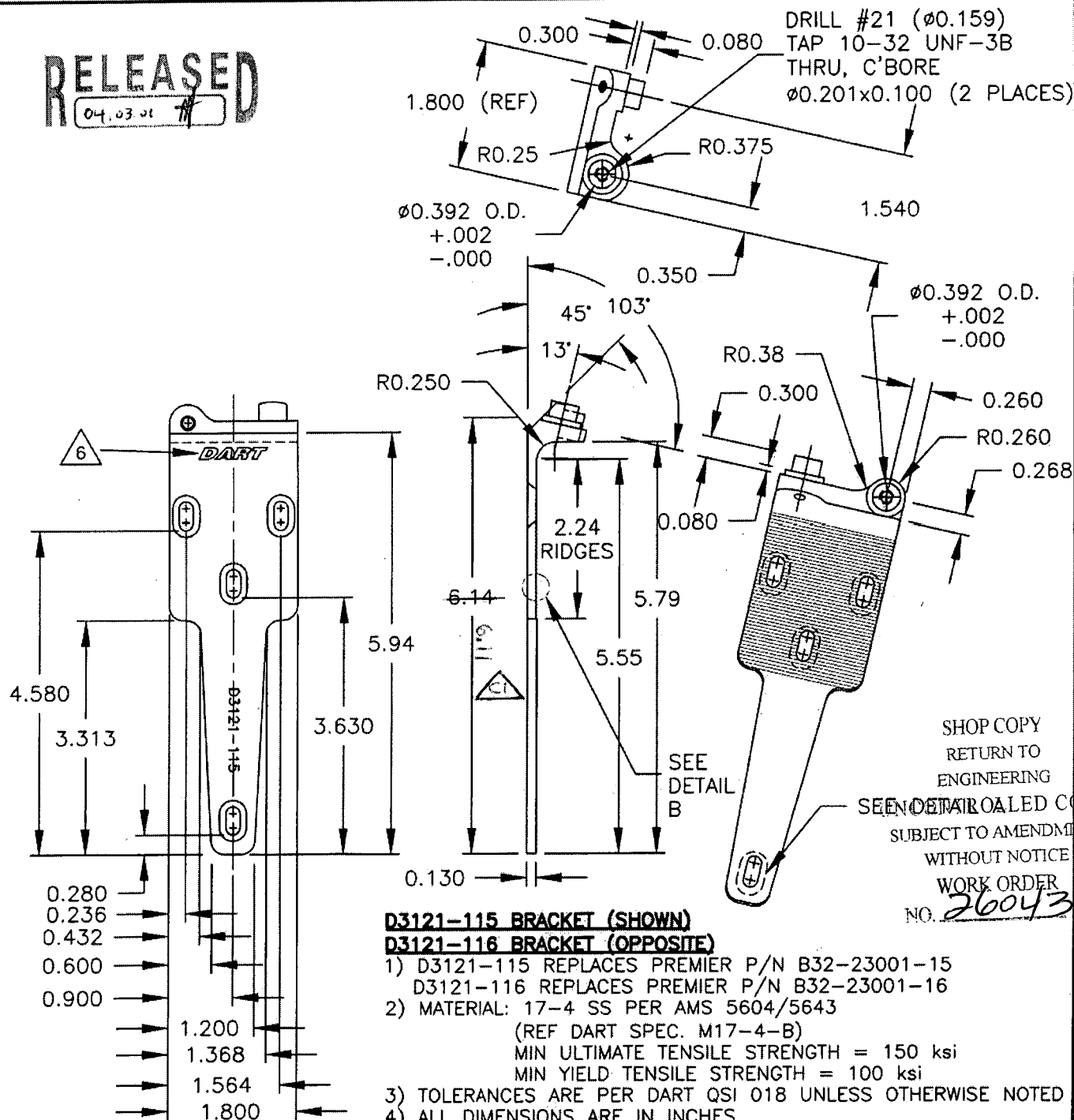
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CHECKED #	APPROVED #	DRAWING NO. D3121	REV. C SHEET 9 OF 10
DATE 04.02.18		TITLE BRACKET ASSEMBLY	SCALE 1:2

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04.03.01 #



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NO. 26043

D3121-115 BRACKET (SHOWN)

D3121-116 BRACKET (OPPOSITE)

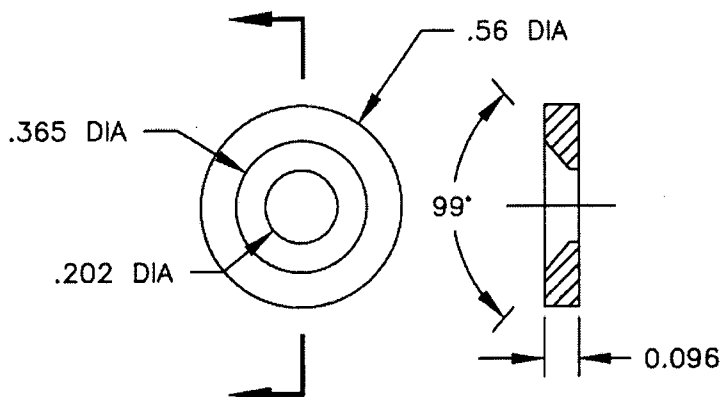
- 1) D3121-115 REPLACES PREMIER P/N B32-23001-15
D3121-116 REPLACES PREMIER P/N B32-23001-16
- 2) MATERIAL: 17-4 SS PER AMS 5604/5643
(REF DART SPEC. M17-4-B)
MIN ULTIMATE TENSILE STRENGTH = 150 ksi
MIN YIELD TENSILE STRENGTH = 100 ksi
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 6) ENGRAVE DART P/N & LOGO IN AREAS SHOWN
- 7) HOLE IN SPIGOT TO BE CONCENTRIC WITHIN 0.005

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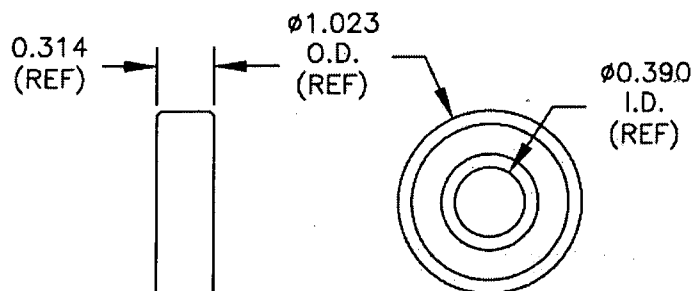
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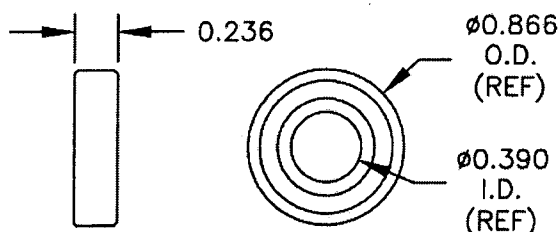
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CHECKED	APPROVED	DRAWING NO. D3121	REV. C SHEET 10 OF 10
DATE 04.02.17		TITLE BRACKET ASSEMBLY	SCALE 1:1

**D3121-17 WASHER (SCALE 2:1)**

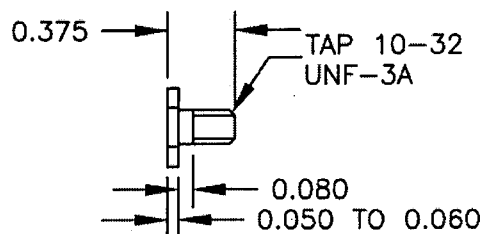
- 1) REPLACES PREMIER P/N B32-23001-17
- 2) MATERIAL: AISI 303 SS ROUND BAR, ANNEALED (REF DART SPEC. M303R)
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.015

**D3121-19 BEARING (SCALE 1:1)**

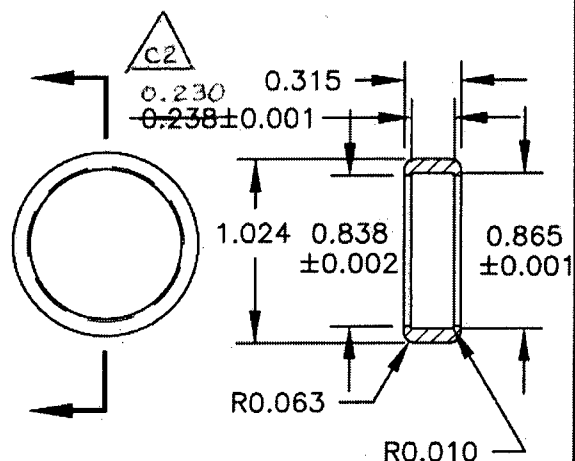
- 1) POSSIBLE SUPPLIER: KING BEARING P/N 6000-2ZJ/EM FAFNIR P/N 9100KDD
- 2) ALL DIMENSIONS ARE IN INCHES

**D3121-23 BEARING (SCALE 1:1)**

- 1) POSSIBLE SUPPLIER: SKF P/N 61900-2Z OR KML P/N 6900-ZZ
- 2) ALL DIMENSIONS ARE IN INCHES

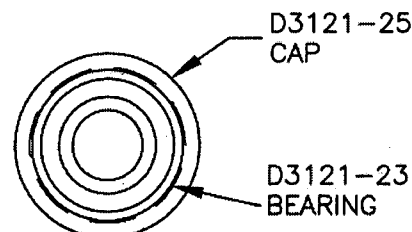
**D3121-21 BOLT (SCALE 1:1)**

- 1) MATERIAL: AISI 303 SS HEX, ANNEALED (REF DART SPEC. M303H0.500)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.015

**D3121-25 CAP (SCALE 1:1)**

- 1) MATERIAL: DELRIN ROD, Ø1.25 (REF DART SPEC. M-DELIN-R1.250)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES

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WORK ORDER
NO. 26043

**D3121-241 BEARING ASSEMBLY (SCALE 1:1)**

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Chris Provencal

From: David Shepherd [davids@dartaero.com]
Sent: March 14, 2006 8:55 PM
To: Chris Provencal
Subject: Re: NCR D3121-113/-114

Acceptable deviation.

David

----- Original Message -----

From: "Chris Provencal" <cprovencal@dartaero.com>
To: <davids@dartaero.com>
Sent: Tuesday, March 14, 2006 2:34 PM
Subject: NCR D3121-113/-114

>
> For one D3121-113/-114 bracket, the 0.160, 1.590, 2.220, & 2.540
dimensions
> on dwg D3121 Rev. C are under tolerance be 0.008" (ie, the 0.160"
dimension
> is 0.142"). What this means is that all four slots are shifted in
relation
> to the rest of the part. The other dimensions are OK. Is this
acceptable?
> I don't think its a big deal because the holes are adjustable anyway and
the
> 0.008" shouldn't make too much of a difference.
>
> Sincerely,
> Chris Provencal
> DART Aerospace Ltd.
> Email..cprovencal@dartaero.com
> Phone....613-632-3336
> Fax.....613-632-4443
>
>